



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2282-5
Job Sheet 174583



Part No: D2282-5

Job Qty: 30 ea

Part Name: Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/19/18

Job Tracking No:

Due Date: 3/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPPRev:B Now on Doosan Lathe 08-06-05 JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		3/22/18	0.00	0.00	Start Up Machining		
100	Doosan	30 pcs		3/23/18	0.03	4.66	Doosan		
120	QC	30 pcs		3/23/18	0.00	0.00	QC8		
130	Packaging	30 pcs		3/23/18	0.00	0.00	Packaging3		
140	QC21-SA	30 Ea		3/23/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Dwg D2282 and Folio FA189
Descriptions: 130 - *****STOCK IN LARGE FAB*****

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304RO.750	304 SS Roundbar .750	5.4018 ft (.18006 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304RO.750	5	82	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Handle Tube	2.170Inches ± 0.030	2.200 2.140		
2	Handle Tube	0.063Inches ± 0.010	0.073 0.053	Radius	
3	Handle Tube	0.063Inches ± 0.010	0.073 0.053		
4	Handle Tube	0.125Inches ± 0.010	0.135 0.115		
5	Handle Tube	0.090Inches ± 0.010	0.100 0.080		
6	Handle Tube	45.000Degrees ± 0.000	45.000 45.000	Angle	
7	Handle Tube	0.350Inches ± 0.010 - 0.000	0.360 0.350	Radius	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

8	Handle Tube	0.158Inches ± 0.010	0.168 0.148	0.168 0.148	
9	Handle Tube	0.386Inches + 0.005 - 0.000	0.391 0.386	0.391 0.386	Diameter
10	Handle Tube	0.700Inches ± 0.010	0.710 0.690	0.710 0.690	Diameter

Plex 3/19/18 10:25 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

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Container No: S055819



Part: D2282 - 5

Job No: 174563

Serial No/Batch: S055819

Revision:

Inspector:

Date: 03/28/18

FAULT CATEGORY

e	☐	Power Loss/Surge	☐	Positioned Wrong
	☐	Folio/Program	☐	Outside Dimensions
	☐	Grain	☐	Over/Under tolerance
	☐	Weld	☐	Part Incorrect
Defect	☐	Wrong Stock Pulled	☐	Part Lost/Missing
	☐	Out of Sequence	☐	Part Moved
	☐	Off-set	☐	Drawing
	☐	Mislabeled	☐	Finish
plete/Unqualified	☐	Fit/Function	☐	Misread
	☐	Misaligned/off center	☐	Turning Sequence